

Work Order ID 160952

Friday, May 05, 2017 10:23:01 AM

160952

Page 1

Item ID: D3868-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 5/16/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 8.00

8

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan:

Date: MAY 05 2017 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3868	REV A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.35

FLOW CNC Waterjet

1-Cut as per Dwg D3868

Dwg Rev: 1Prog Rev: 1

2-Deburr if necessary

⑧

5/17/05/10

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

⑧

5/17/05/10

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⑧

DAS
38
9-89

MAY 11 2017

Friday, May 05, 2017 10:23:01 AM

Page 2

BEB

Work Order ID 160952

Friday, May 05, 2017 10:23:01 AM

160952

Page 3

Item ID: D3868-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 5/16/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 5/18/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				8			DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAY 15 2017
170	Identify as per dwg & Stock Location: <i>Sto 34</i>	0.00				8			DA 6 9-89
170									
Packaging	Memo	0.00							
Packaging									MAY 16 2017
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									17/5/16 <i>df</i>

DAS
21
9-89

MAY 16 2017

Picklist Print

Friday, May 05, 2017 10:23:01 AM

Page 1

Work Order ID: 160952

160952

Parent Item: D3868-5

D3868-5

Parent Item Name: Spacer

Start Date: 5/16/2017

Required Date: 5/18/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No		100	sf	132.6300	0.0084	0.008421			
M6061T6S 040									**				
6061-T6 .040 Sheet													

54/17/05/10

Location

Loc Qty

Loc Code

MAT

64

m137165

64

MAT021

68.63

m135612

25.35

m135632

3.51

m135724

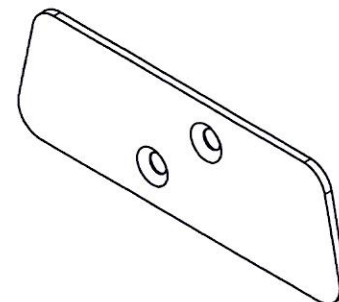
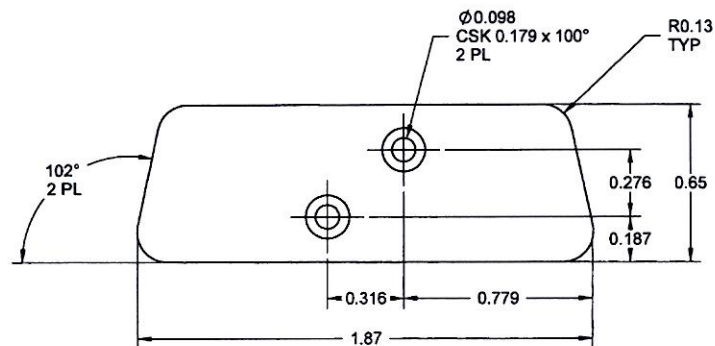
4.47

m136790

35.3

M133548

01



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 100952

MAY 05 2017

D3868-5 SPACER

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 Lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3868	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE SPACER	SCALE
DE APPR.			NTS
DATE	09.01.13	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	